

Date: Thursday, 11/12/2008 8:31:59 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2894-1
Job Number : 43976	
Estimate Number : 13235	
P.O. Number :	Part Number : DSK079
This Issue : 11/12/2008 S.O. No. :	Drawing Number : DSK079 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 38132	Material :
Written By :	Due Date : 18/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.12.12</u>	
Comment : est rev A. 08.03.13 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104009	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

Batch:

41968

20 08/12/14

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn blank as per Folio FA253

DASAN

20 08/12/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/12/14

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J-F. 08/12/15

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

20 08/12/15 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 8:31:59 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2894-1

Job Number: 43976

Part Number: DSK079

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43974	
Description: Turning Detail for D2894-1		Part Number:	DSK079
Inspection Dwg: DSK079	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.778	2.783		2.782	2.782	2.782	2.782	2.782
B	3.990	4.010		3.998	3.998	3.998	3.998	3.998
C	3.088	3.108		3.101	3.101	3.101	3.101	3.101
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.968	2.988		2.980	2.980	2.980	2.980	2.980
G	1.410	1.430		1.420	1.420	1.420	1.420	1.420
H	1.150	1.160		1.158	1.158	1.158	1.158	1.158
I	5.240	5.260		5.250	5.250	5.250	5.250	5.250
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.090	0.110		.101	.101	.101	.101	.101

Measured by: 20	Date: 08/12/15
Audited by: J.F.	Date: 08/12/15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43976
Description: Turning Detail for D2894-1		Part Number: DSK079
Inspection Dwg: DSK079	Rev: A	Page 1 of 1





FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

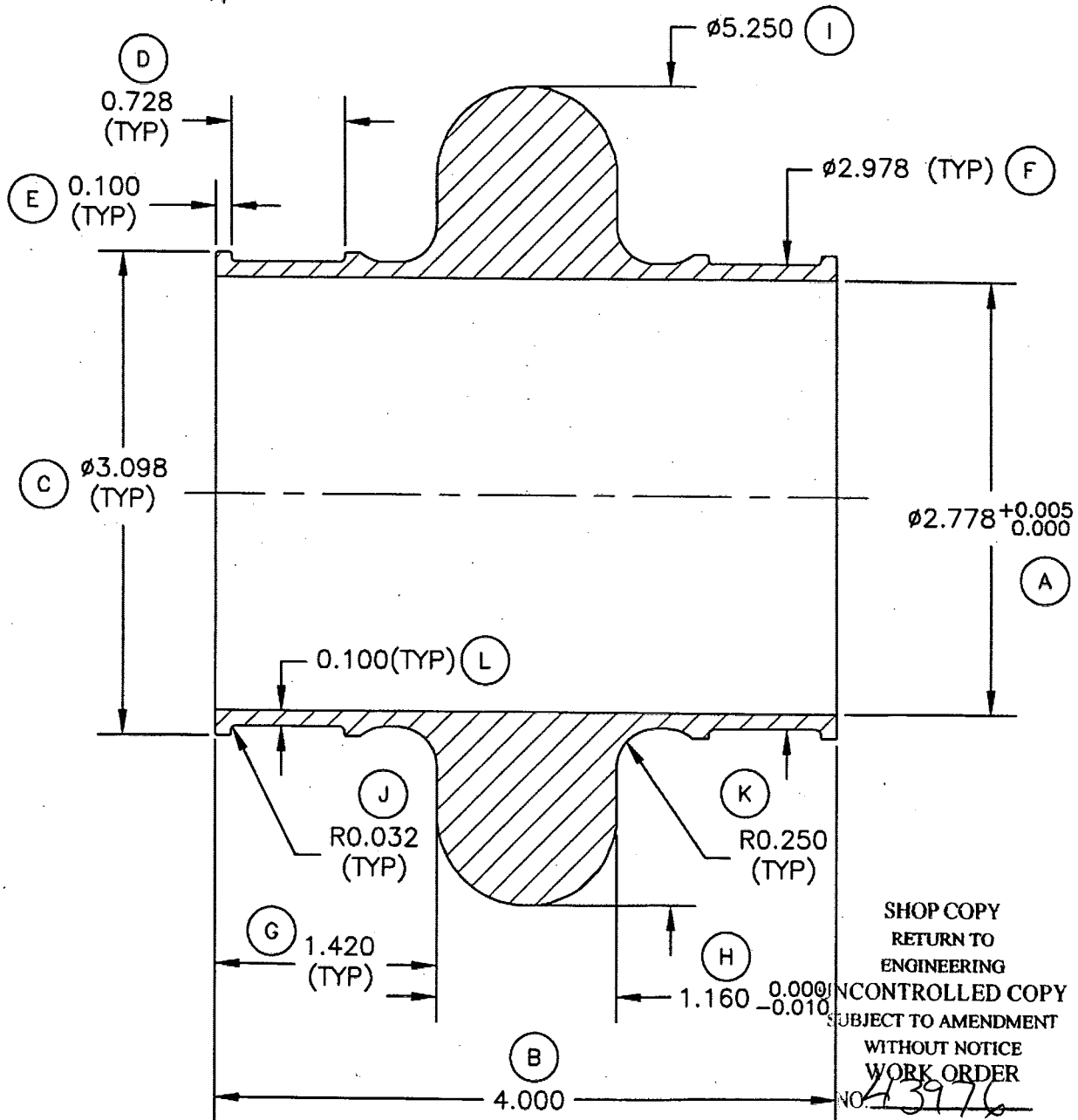
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
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Measured by: <i>OP</i>	Date: 08/12/15
Audited by: J.F.	Date: 08/12/15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSK 079	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2894-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2894-1 TURNING DETAIL

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